



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D2741
Job Sheet 171547



Part No: D2741

Job Qty: 40 ea

Part Name: Replacement Blade



Part Weight: 0 lbs

Status: Scheduled

Priority: High

Job Created: 2/2/18

Job Tracking No:

Created By: Linda Lacelle

Due Date: 2/19/18

Type: Stock

Description:

Note: DWG REV E IPP Rev: D 00.11.15 Removed P/O turning - in house process EC IPP Rev: E 06-03-20 As Per Rev C JLM IPP Rev: F

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	40 Ea		2/15/18	0.00	0.00	Start Up Machining-1		SC 18/08/09
100	Bandsaw	40 pcs		2/16/18	0.00	3.11	Bandsaw1		IC 18/02/09
110	CNC Vertical Machining	40 pcs		2/17/18	0.00	27.45	HAAS1-2		S.C. 18/08/14
130	QC	40 pcs		2/17/18	0.00	0.00	QC8 Machining-1		18/02/15
140	Small Fab	40 pcs		2/17/18	0.04	0.68	Small Fab-2		S.S. DAS
150	QC	40 pcs		2/17/18	0.00	0.00	QC5		38
160	Outsource	40 pcs		2/17/18	0.00	0.00	Outsource1	3918.1	MAR 16 2018
170	Packaging	40 pcs		2/17/18	0.00	0.00	Packaging2		18/03/14
180	QC	40 pcs		2/17/18	0.00	0.00	QC5		38
190	HandFinish	40 pcs		2/17/18	0.00	2.47	HandFinish4		SA 18-3-23
200	Powdercoat	40 pcs		2/19/18	0.00	1.02	Powdercoat2		18-3-28
210	QC	40 pcs		2/19/18	0.00	0.00	QC3		11
220	Packaging	40 pcs		2/19/18	0.00	0.00	Packaging3-1	5138	MAR 31 2018
230	QC21-SA	40 Ea		2/19/18	0.00	0.00	QC21		9-89

Part Op 100 - Cut blanks 13.850" long +0.063" -0.000"

Descriptions: 110 - 1-Machine per folio FA108

140 - 1-Deburr

160 - Issue P/O:

170 - Ensure Test report or Certification attached

190 - clean with wash & wipe to remove oil

200 - START TIME: 2:20

OUT. 760° FINISH: 2:55 M138760

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M4130NB0.500X03.000	4130 Bar 0.500 X 3.00	46.1640 ft (1.1541 ea)	90-Start up Operation	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M4130NB0.500X03.000	46	106	0

5024353 - 5024353

DART
AEROSPACE
S040883

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K64 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com



Replacement Blade

PART NO: D2741
Original Serial #: S040883
Revision:
Operation:
Change No:

Start up Operation 02/09/18
Job No: 171547

Part Specifications					
Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Blade	1.500Inches ± 0.010	1.510 1.490	1.500	
2	Blade	0.715Inches ± 0.010	0.725 0.705	.716	
3	Blade	0.516Inches $+ 0.008$ $- 0.001$	0.524 0.515	Diameter .516	
4	Blade	2.000Inches ± 0.030	2.030 1.970	2.020	
5	Blade	13.750Inches ± 0.010	13.760 13.740	13.755	
6	Blade	1.060Inches $+ 0.012$ $- 0.001$	1.072 1.059	Diameter 1.06	
7	Blade	0.150Inches ± 0.010	0.160 0.140	.145	
8	Blade	2.930Inches ± 0.030	2.960 2.900	2.930	
9	Blade	0.375Inches ± 0.010	0.385 0.365	.375	
10	Blade	0.250Inches ± 0.030	0.280 0.220	.25	
11	Blade	0.250Inches ± 0.030	0.280 0.220	.25	

Plex 2/2/18 1:40 PM dart.lacelle.linda

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

 QA Closed: **DAS 53**
 Date: **MAY 29 2018**
 9-89
Work Order update only ☐

Work Order: <u>171547</u> Part No. <u>D2741</u> NCR No. <u>18-6879</u>		DISPOSITION Rework ☐ Scrap ☒ PM Use-as-is ☐ Suspected Unapproved ☒		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☒ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date: <u>18.02.14</u>		Step #: <u>180</u>		QTY Effective: <u>(2)</u>		MRB (QSI042) Approval	
Description Work Order Deviation				Disposition			
2 pieces are under specified tolerance on thickness R.C part left during machining				scrap and destroy no replace			
				PD 18.02.15 Completed By S.C. 18/02/14 Lead hand / Supervisor Approval Verification OK 18/02/15 QC / QA Coordinator Approval PD 18.02.15			
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☒ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☒ PM Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐				FAULT CATEGORY Pressure/Forced ☐ Bending ☒ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☒ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER :							

Customer	Order No	PO	Customer Part	Due Date	Ship Date	new ship date	Quantity	Balance	Qty Ready	status	responsible
CHAWK03	710	225939-3521	RB T101808-153P	10/3/2017	10/3/2017		4	4	0	stk	
CHMAR01	744	A111674	RBD29823-5A	10/13/2017	10/13/2017		2	2	0	outsource??	
CHELI02	10	HWS PO 17D	D119 646 011	10/27/2017	10/27/2017	11/23/2017	1	1	0	pkg	machining/ stores/pkg
CHELI02	10	HWS PO 17D	D119 646 011	10/27/2017	10/27/2017	11/23/2017	1	1	0	pkg	machining/ stores/pkg
CHELI02	10	HWS PO 17D	D119 646 012	10/27/2017	10/27/2017	11/23/2017	1	1	0	pkg	pkg
CHELI02	10	HWS PO 17D	D119 646 012	10/27/2017	10/27/2017	11/23/2017	1	1	0	pkg	pkg
CHELI02	10	HWS PO 17D	D119 796 101	10/27/2017	10/27/2017	11/23/2017	1	1	0	stk	
CHELI02	10	HWS PO 17D	D119 796 101	10/27/2017	10/27/2017	11/23/2017	1	1	0	pkg	pkg
CHELI02	10	HWS PO 17D	D119 796 201	10/27/2017	10/27/2017	11/23/2017	1	1	0	stk	
CHELI02	10	HWS PO 17D	D119 796 201	10/27/2017	10/27/2017	11/23/2017	1	1	0	pkg	pkg
CCAMP01	638		D3199-1	10/27/2017	10/27/2017	11/30/2017	18	18	5	stk	
CCAMP01	638		D3202-1	10/27/2017	10/27/2017	11/30/2017	2	2	8	stk	
CADVA02	383		647.3804	10/31/2017	10/31/2017	11/30/2017	1	1	0	pick kit	stores/pkg
CADVA02	383		647.4310	10/31/2017	10/31/2017		1	1	5	stk	
CADVA02	383		647.4311	10/31/2017	10/31/2017		1	1	5	stk	
CDUBA01	3	PUR007830	D139-799-039	11/1/2017	11/1/2017		2	2	2	test fit first	
CHOCE01	112	PO-608	D2332-041	11/1/2017	11/1/2017		1	1	2	\$\$	
CPACI17	130	POBSB1AA0R	D350-607-541	11/1/2017	11/1/2017		1	1	1	\$\$	
CPACI17	130	POBSB1AA0R	D350-607-541	11/1/2017	11/1/2017		1	1	1	\$\$	
CHELI51	278	54/09-2017	D350-822-011	11/1/2017	11/1/2017		1	1	5	\$\$	
CHCH01	681	8049363	HT 500 010P 14	11/1/2017	11/1/2017		1	1	0	\$\$	
CNATI01	716	EC/17/002	RBEM12669/P-1P	11/1/2017	11/1/2017		1	1	0	\$\$	PURCHASED IN
CPROF05	723	PO12125	RB PWC34910-200	11/1/2017	11/1/2017		1	1	0	\$\$	PURCHASED
CSHAN06	734	Email from W	C2-HCP	11/1/2017	11/1/2017		1	1	0	\$\$	PURCHASED IN
CAEAV01	752	QU125657	RB T101529-131P	11/1/2017	11/1/2017		1	1	0	\$\$	PURCHASED BY
GSAFE05	927	PO-1711004	RB T101577 1P	11/1/2017	11/1/2017		1	1	0	\$\$	PURCHASED INT
CHWES03	1171	PO14803	D2461 0870	11/1/2017	11/1/2017		1	1	3	\$\$	
CHWES03	1171	PO14803	D2463 0870	11/1/2017	11/1/2017		1	1	13	\$\$	
CSPEC07	1360	SPC 17393	D2011 101	11/1/2017	11/1/2017		2	2	55	\$\$	
CSPEC07	1360	SPC 17393	D3014 1	11/1/2017	11/1/2017		2	2	59	\$\$	
CSPEC07	1360	SPC 17393	NAS1149D0416J	11/1/2017	11/1/2017		2	2	3490	\$\$	
GPROF05	1427	PO12303	D2732 030	11/1/2017	11/1/2017		20	20	440	\$\$	
CALPI02	328	PK-157655	41232-000-001-001	11/3/2017	11/3/2017	11/29/2017	1	1	0	waiting on DSI	ENG
CALPI02	328	PK-157655	41232-000-001-002	11/3/2017	11/3/2017	11/29/2017	1	1	0	waiting on DSI	ENG
CAGUS03	16	4801569142	6F9540V00231	10/3/2017	11/6/2017	11/29/2017	1	1	0	pick kit	stores/pkg
CAGUS03	16	4801569142	6F9540V00231	10/3/2017	11/6/2017	11/29/2017	1	1	0	pick kit	stores/pkg
CAGUS03	16	4801569142	6F9540V00231	10/3/2017	11/6/2017	11/29/2017	1	1	0	pick kit	stores/pkg



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER

PO039181

Supplier: MEI001-VC
Metcor Inc.
560 Boul. Arthur Sauve
Saint-Eustache
QC
J7R 5A8 Canada
Phone: 450 473 1884
Fax: 450 491 5498

PO No: PO039181

PO Date: 3/2/18

Due Date: 3/20/18

Purchase Order

Revision:

Revision Date:

Ship-To Contact: Lacelle, Linda
Phone: llacelle@dartaero.com

REVISED

\$

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

Via: Ground

Pymt Terms: Net 30

Freight Terms:

Special Comments:

Items

Line Item	Job	Part	Description	Status	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	171547	D2741	Replacement Blade Issue P/O: HARDEN MATERIAL: ULTIMATE TENSILE STRENGTH = 152 KSI MINIMUM YIELD TENSILE STENGHT = 141 KSI (34-40 HRC) SAND BLAST PART AFTER HEAT TREAT NOTE: DO NOT OIL AFTER SANDBLAST NOTE: DETAIL C OF C REQUIRED	Firmed	3/27/18	38 pcs	0 pcs	38 pcs	\$18.395263/pcs	\$699.02

Line Item Note part made from 4130 bar

10 171726 RB Sleeve
T102137- 1-Issue P/O to Metcore ;
107-107 P/O
RC 32-37
2-Bead blast
3- Certificate of
Conformity is required

Firmed 3/20/18 6 pcs 0 pcs 6 pcs \$50.00/pcs \$300.00

Line Item Note part made from 4140N round bar 0.875"

11 171725 RB Strap
T102137- 1-Issue P/O to Metcore ;
107-105 P/O
RC 46-50
2-Bead blast
3- Certificate of
Conformity is required

Firmed 3/20/18 6 pcs 0 pcs 6 pcs \$50.00/pcs \$300.00

Line Item Note part made from 4140N round bar 0.625"

Grand Total: \$1,299.02

METCOR INC.

560 BOUL. ARTHUR-SAUVÉ, ST-EUSTACHE, QC, J7R 5A8

Tél.: 450-473-1884

Télécopieur / Fax administration: 450-491-5498

Télécopieur / Fax production: 450 491-6454

Certificat de Conformité

Certificate of Compliance

BON DE TRAVAIL order	CHARGEMENT load
325892	1

CLIENT / customer 215

DART AEROSPACE

1270 ABERDEEN

HAWKESBURY

ON K8A 1K7

LIVRÉ À / shipped to:

DART AEROSPACE

1270 ABERDEEN

HAWKESBURY

ON K8A 1K7

1

COMMANDE DU CLIENT customer po	CLASSIFICATION PIECE part classification	MATÉRIEL material	MAÎTRE D'OEUVRE prime contractor	PROGRAM
PO039181	N/A	4130		

SPÉCIFICATIONS DU PROCÉDÉ

processing specifications

SEL HARDEN

HARDEN AND TEMPER

SAE AMS 2759/1 REV.E

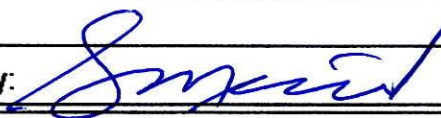
EXIGENCE / requirement	SPÉCIFICATIONS / specified	TESTS EXÉCUTÉS / performed	RÉSULTATS DE TESTS / results
HARDNESS	34 - 40 HRC	38	38 - 40 HRC
TENSILE (KSI)	152 - 182 KSI		171 - 182 KSI

QUANTITÉ quantity	POIDS weight	DESCRIPTION DES PIÈCES parts description
38	133	D2741 BLADE (38) D2741 JOB 171547 1 BOITE DE BOIS

16/3/18

COMMENTAIRES / comments

APPROUVÉ par / Approved by:



DATE: 2018-03-14

METCOR INC.
 200 BOUTRIER DRIVE SUITE 200
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QUANTITE quantity	Poids weight	Désignation des pièces parts designation
06	108	TOTAL
		BLADE
		JOINT
		JOINT
		BOITE DE POIR

COMMENTS : comments

44-38861-105 TTAG

APPROVED BY: Approved by:

METCOR INC.

560 BOUL. ARTHUR-SAUVÉ, ST-EUSTACHE, QC, J7R 5A8

Tél.: 450-473-1884

Télécopieur / Fax administration: 450-491-5498

Télécopieur / Fax production: 450 491-6454

Certificat de Conformité Détaillé

Detailed Certificate of Compliance

BON DE TRAVAIL order	CHARGEMENT load
325892	1

CLIENT / customer 215

DART AEROSPACE

1270 ABERDEEN

HAWKESBURY

ON K6A 1K7

LIVRÉ À / shipped to:

DART AEROSPACE

1270 ABERDEEN

HAWKESBURY

ON K6A 1K7

1

COMMANDE DU CLIENT customer po	CLASSIFICATION PIECE part classification	MATÉRIEL material	MAÎTRE D'OEUVRE prime contractor	PROGRAM
PO039181	N/A	4130		
SPÉCIFICATIONS DU PROCÉDÉ processing specifications SEL HARDEN HARDEN AND TEMPER SAE AMS 2759/1 REV.E				
EXIGENCE / requirement SPÉCIFICATIONS / specified TESTS EXÉCUTÉS / performed RÉSULTATS DE TESTS / results				
HARDNESS	34 - 40 HRC	38	38 - 40 HRC	
TENSILE	152 - 182 KSI	1	165.4 - 165.4 KSI	
METCOR REPORT # 4518 ; VO				
QUANTITÉ quantity	POIDS weight	DESCRIPTION DES PIÈCES parts description		
38	133	D2741 BLADE (38) D2741 JOB 171547 1 BOITE DE BOIS		

COMMENTAIRES / comments

SALT HARDEN 1575F, 40 MIN

SNAP TEMPER 400F, 2 HRS

TEMPER 875F, 4 HRS

Le traitement thermique (TT) a été fait en utilisant des équipements en conformité avec AMS2759 et AMS 2750.

Le TT a été fait tel que requis par AMS2759 et toutes les vérifications et les tests demandés ont été faites et documentés.

Aucun changement n'a été faite par rapport au TT. On certifie que le matériel a été fabriqué, échantillonné, testé et inspecté en accord avec AMS2759 et le bon de commande et le matériel rencontre les exigences spécifiées.

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Heat treatment (HT) was performed with equipment that meets the requirements of AMS2759 & AMS2750.

All HT operations were in compliance with AMS2759 and all verifications have been performed and documented. No unauthorized changes were performed in regards to the HT. We certify that the material was manufactured, sampled, tested and inspected in accordance with AMS2759 and the purchase order and was found to meet the requirements.

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METCOR INC.

560 BOUL. ARTHUR-SAUVÉ, ST-EUSTACHE, QC, J7R 5A8

Tél.: 450-473-1884

Télécopieur / Fax administration: 450-491-5498

Télécopieur / Fax production: 450 491-6454

Certificat de Conformité Détaillé

Detailed Certificate of Compliance

BON DE TRAVAIL order	CHARGEMENT load
325892	1

CLIENT / customer 215

DART AEROSPACE

1270 ABERDEEN

HAWKESBURY

ON K6A 1K7

LIVRÉ À / shipped to:

DART AEROSPACE

1270 ABERDEEN

HAWKESBURY

ON K6A 1K7

1

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APPROUVÉ par / Approved by:

Vincent Conetta



DATE: 2018-03-20



Mar 20, 2018

ASTM E8 / 0.2% OFFSET YIELD / 1" GL.(4d)

Report No. 4518

Test Date 20-Mar-18 Testing Machine STM-100KN 0211506

Client DART AEROSPACE
Operator Viorel Oltean
Material 4130

PO po039181
W.O. 325892

Part # D2741

Load Cell S/N (TVI110012), Units (LBS)

22480

Crosshead Speed (Inches / min) or Rate 0.5

Displacement Sensor

EZ.1-1 (5286)

Notes Results are in compliance with customer and specification requirements.

Test No	Specimen ID	Diameter (in)	Yield (kpsi)	Tensile (kpsi)	Total Elong (%)	RA (%)
10339	325892-1	0.250	154.8	165.4	15.6	58.5
	Mean	0.250	154.8	165.4	15.6	58.5
	Std Dev					
	Specification (min)			152.0		
	(max)			182.0		

By:



Date: Mar 20, 2018

Test Performed in Accordance with ASTM E 8, Rev. 16a

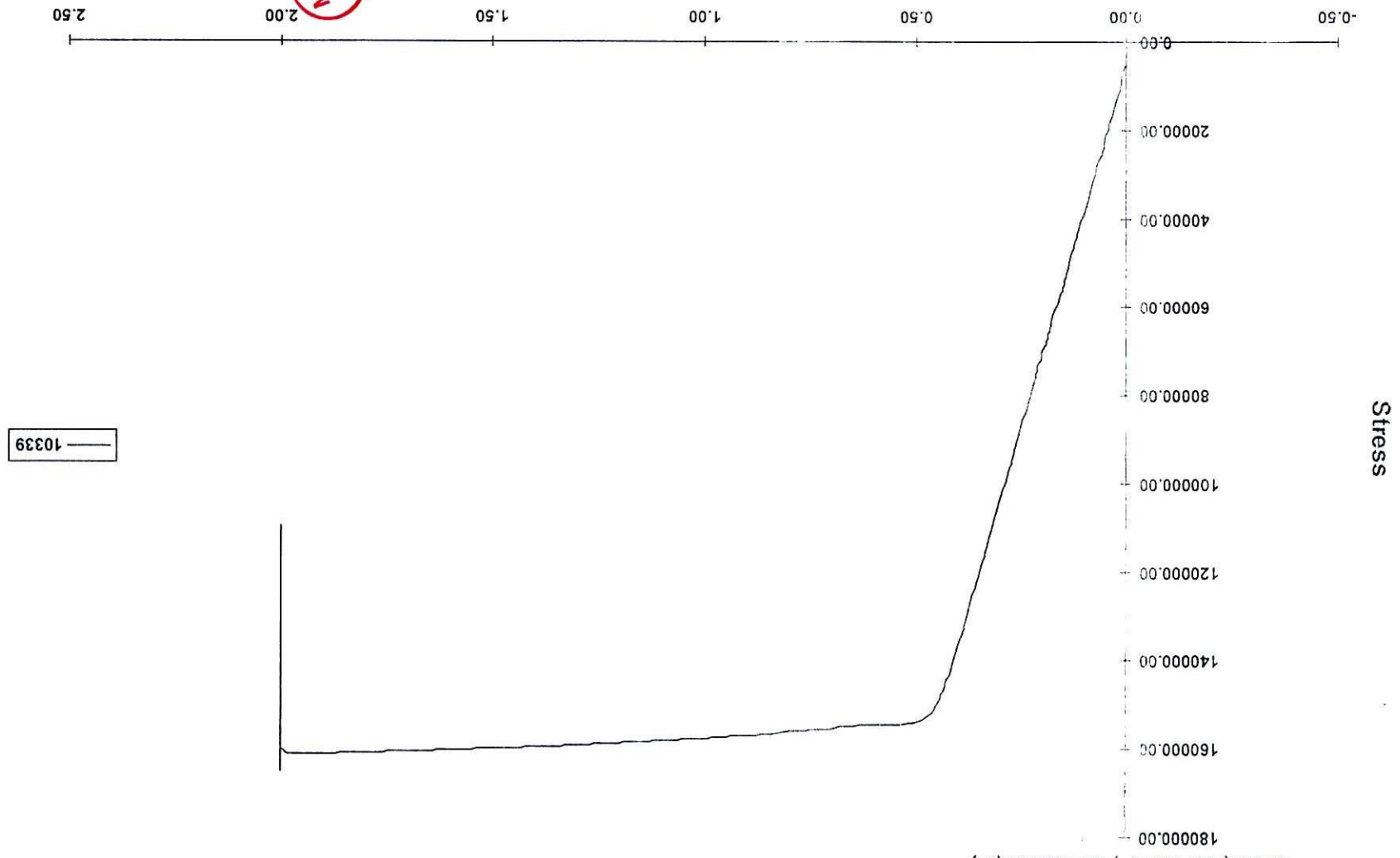
Metcor 560 Boul Arthur-Sauve St-Eustache, Quebec J7R 5A8

TEL 450-473-1884 FAX 450-491-5498



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ASTM E8 / 0.2% OFFSET YIELD / 1" GL.(4d)

Stress (Lbs / Inches²) vs Extension (%)



10339



Extension

METCOR INC.

500 BOUL. ARTHUR SAUVÉ, ST-EUSTACHE, QC, J7R 5A3

Tél: 450-473-1884

Télécopieur / Fax administration: 450-491-5498

Télécopieur / Fax production: 450-491-6454

Certificat de Conformité Certificate of Compliance

BON DE TRAVAIL order	CHARGEMENT load
325892	1

CLIENT / customer 215

DART AEROSPACE

1270 ABERDEEN

HAWKESBURY

ON K8A 1K7

LIVRÉ À / shipped to:

DART AEROSPACE

1270 ABERDEEN

HAWKESBURY

ON K8A 1K7

COMMANDE DU CLIENT customer po	CLASSIFICATION PIÈCE part classification	MATÉRIEL material	MAÎTRE D'OEUVRE prime contractor	PROGRAM
PO038181	N/A	4130		

SPÉCIFICATIONS DU PROCÉDÉ

processing specifications

SEL HARDEN

HARDEN AND TEMPER

SAE AMS 2759/1 REV.E

EXIGENCE / requirement	SPÉCIFICATIONS / specified	TESTS EXÉCUTÉS / performed	RÉSULTATS DE TESTS / results
HARDNESS	34 - 40 HRC	38	38 - 40 HRC
TENSILE (KSI)	152 - 182 KSI		171 - 182 KSI

QUANTITÉ quantity	POIDS weight	DESCRIPTION DES PIÈCES parts description
38	133	D2741 BLADE (38) D2741 JOB 171547 1 BOITE DE BOIS

16/3/18

COMMENTAIRES / comments

APPROUVÉ par / Approved by:



DATE: 2018-03-14